

Date: Wednesday, 12/14/2005 3:56:49 PM
 User: Kim Johnston

Process Sheet

60

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: RADIUS BLOCK		
Job Number	: 25223					
Estimate Number	: 10822					
P.O. Number	: N/A			Part Number	: D2274	
This Issue	: 12/14/2005		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D2274 REV F	
First Issue	: 12/14/2005		Type	: MACHINED PARTS		
Previous Run	: 24872			Project Number	: N/A	
Written By	: See comment below			Drawing Revision	: F	
Checked & Approved By	: See comment below			Material	: N/A	
Comment	: Est. H 00.05.18 Added inspection level 8 EC			Due Date	: 12/21/2005	
					Qty:	500 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0750X00125	6061-T6 Bar .75" x .125"	
		Comment: Qty.: 0.0962 f(s)/Unit Total : 48.0900 f(s) 6061-T6 Bar .75" x .125" Shear blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2274	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble Deburr any rough edges after tumbling	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/12/16	2	10 parts scrapped Parts popped out of W.R.	QA/42	Scrap and clean up and replace	6 CD 05/12/16	✓ 06-01-04	QA/42	J 06-01-04

NOTE: Date & initial all entries

Date: Wednesday, 12/14/2005 3:56:49 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RADIUS BLOCK

Job Number: 25223

Part Number: D2274

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DL 05/12/22 506

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ML 05/12/22 506

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 30

UV 06/07/03 506

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21 506 06/01/04 506

DO 06/01/04 506

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA  Date: 06/01/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25223
Description: Radius Block	Part Number:	D2274
Inspection Dwg: D2274	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>E.P.</u>	Audited by:	<u>J.G.</u>	Prototype Approval:	<u>N/A</u>
Date:	<u>05/21/16</u>	Date:	<u>05/12/16</u>	Date:	<u>N/A</u>

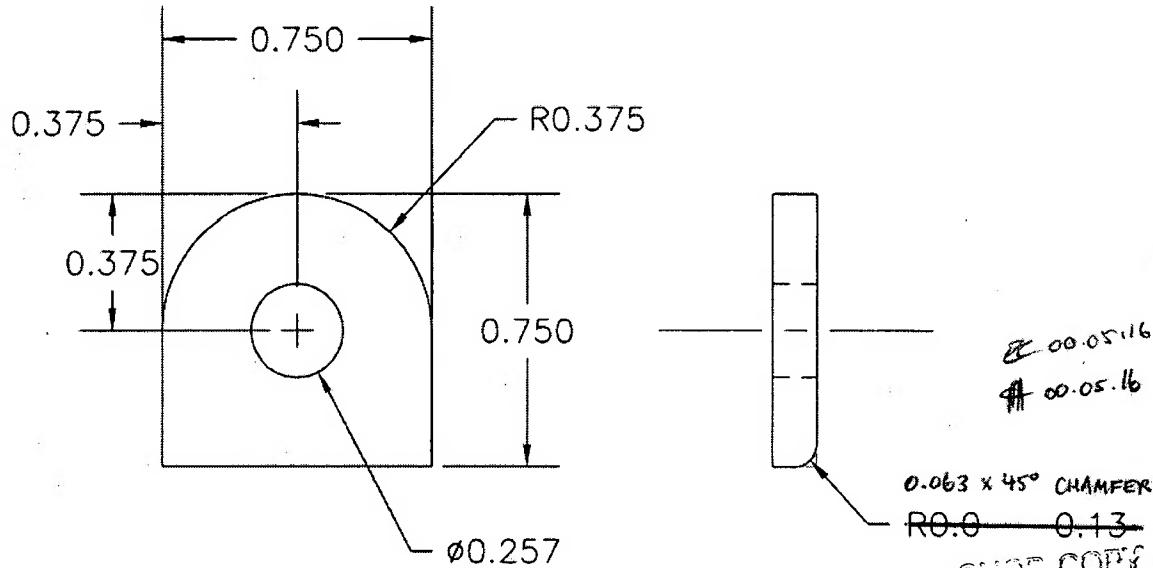
Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	

DART

DESIGN <i>RE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>NO</i>	APPROVED <i>AS</i>	DRAWING NO. D2274
DATE 98.08.11		REV. F SHEET 1 OF 1 TITLE RADIUS BLOCK SCALE 2:1

RELEASED
98/08/18 KE

A	94.09.29	NEW ISSUE
C	95.07.12	RADIUS ENDS
D	97.03.24	ADD MATERIAL SPECIFICATION
E	97.12.12	ADD FINISH & TOLERANCE QSI
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125



MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
 OR 6061-T6 (QQ-A-250/11) 0.125 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

